SECTION 8-21, PERMANENT SIGNING
September 30, 1996

8-21.2 Materials
The second sentence of the first paragraph is revised to read:

Materials for sign bridges, cantilever sign structures, roadside sign structures, and sign mounting shall meet the requirements of Section 9-06.

8-21.3(6) Sign Refacing
The reference to "13-millimeter" in the fourth sentence of the second paragraph is revised to read "6-millimeter".

8-21.3(9)F Bases
The second sentence of the second paragraph is revised to read:

Spiral foundation reinforcement shall conform to ASTM A 82 for sign post bases and Section 9-07 for all other sign structure bases.

The second paragraph is supplemented with the following:

Concrete for sign post foundations shall be Class 20 conforming to the requirements of Section 6-02.3.

8-21.3(10)A Sign Lighting Luminaires
The reference to "Section 9-28.16" in the first sentence is revised to read "Section 9-28.15".

8-21.3 Construction Requirements
This section is revised by adding the following new section:

8-21.3(12) Steel Sign Posts
Steel sign posts shall be connected to concrete bases using the following procedure:

1. Remove all galvanized runs and beads from washer area.
2. Assemble sign post to stub post with bolts, using one flat washer on each bolt between plates.
3. Shim as required to plumb sign posts.
4. Tighten bolts in a systematic order to required torque while not over tightening.
5. Loosen each bolt and retighten to required torque in the same order as initial tightening.
6. After Contracting Agency inspection of bolt torque, burr threads with center punch to prevent loosening.

When AASHTO M 183M or ASTM 36M steel is used for posts, a welded bead approximately 50 millimeters long shall be placed on the post approximately 150 millimeters from the base connection. When AASHTO M 222M, AASHTO M 223M, ASTM A 572M Grade 345, or ASTM A 53 Grade B steel is used, 2 welded

1   beads approximately 50 millimeters long and 15 millimeters apart shall be placed
2   on the post approximately 150 millimeters from the base connection.